

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019874**Date Inspected:** 18-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations relative to the work being performed.

OBG Segment Name: 11DE / Bay 14

This Caltrans QA inspector observed Flux Cored Arc Welding (FCAW) in progress. Welders are identified as #0447741 and #058551 welding in the 3G position using welding procedure specification WPS-B-T-2233-B-U2-F. The welds are identified as SSD17-PP105 and SSD17-PP103. ZPMC QC inspectors are identified as Mr. Zhong Guo Hai and certified welding inspector (CWI), Mr. Lv Liqing. The welding variables recorded by QC appeared to comply with the WPS.

OBG Segment Name: 12CW / Bay 14

This Caltrans QA inspector observed Submerged Arc Welding (SAW) in progress. Welder operator is identified as #045265 welding CJP weld in the 1G position using WPS-B-T-2221-B-L2c-S-2. The weld is identified as SEG3006W-002. ZPMC QC inspectors are identified as Mr. Xu Tao and CWI, Mr. Liu Hua Jie. The welding variables recorded by QC appeared to comply with the WPS.

OBG Segment Name: 10CW / Bay 14

This Caltrans QA inspector observed Shielded Metal Arc Welding (SMAW) in progress. Welders are identified as #067764 in the 4G position using WPS-B-P-2114-TC-U4b-FCM-1. The weld is identified as SSD10A-PP092-252 and -253. ZPMC QC inspectors are identified as Mr. Li Ming Ming and CWI, Mr. Liu Hua Jie. The welding variables recorded by QC appeared to comply with the WPS.

WELDING INSPECTION REPORT

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OBG Segment Name: 8AW / North of Blast Shop

This Caltrans QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG T-Stiffener to Side Plate (Hold Back Weld) Component. The weld designations reviewed are as follows:

-(SP763B-637-014 ~ 024)

-(SP723B-623-044 ~ 053)

See Caltrans Magnetic Particle Test Report (TL6028), date 12-18-09 for additional information.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

“As noted within the contents of this report.”

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	Riley, Ken	QA Reviewer
